

BLUR

SLIT

Dart Aerospace Ltd.

Date: Monday, 25/06/2007 3:02:39 PM  
User: Linda Lacelle



Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG EXTRUSION
Job Number	: 33136		
Estimate Number	: 10326 -2		
P.O. Number	: N/A	Part Number	: D27317
This Issue	: 25/06/2007	Drawing Number	: D2731 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 33135	Material	: N/A
		Due Date	: 02/07/2007
Written By	:	Qty:	40 Jm: Each
Checked & Approved By	:		
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC		



Additional Product



Job Number: 

Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
		
Comment: Qty.: 0.0717 f(s)/Unit Total: 2.8686 f(s)		
Lug Extrusion D2423		
Batch: 300602 C207106125 28084		

2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW		
Cut D2423 extrusion to .82"		
Batch: _____		













3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Issue P.O 4040 C207106125		
Comment: HAAS CNC VERTICAL MACHINING #1		
1-Machine as per folio D2731-7.		
2-Check for crack while loading into the machine.		
3-Tumble		
4-Deburr any rough edges after tumbling		

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Receive & inspect for tensile damage		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
6/7/28 (40)		

5.0	QC5	SECOND CHECK
		
Er 07/06/29		
Comment: SECOND CHECK		
(440)		

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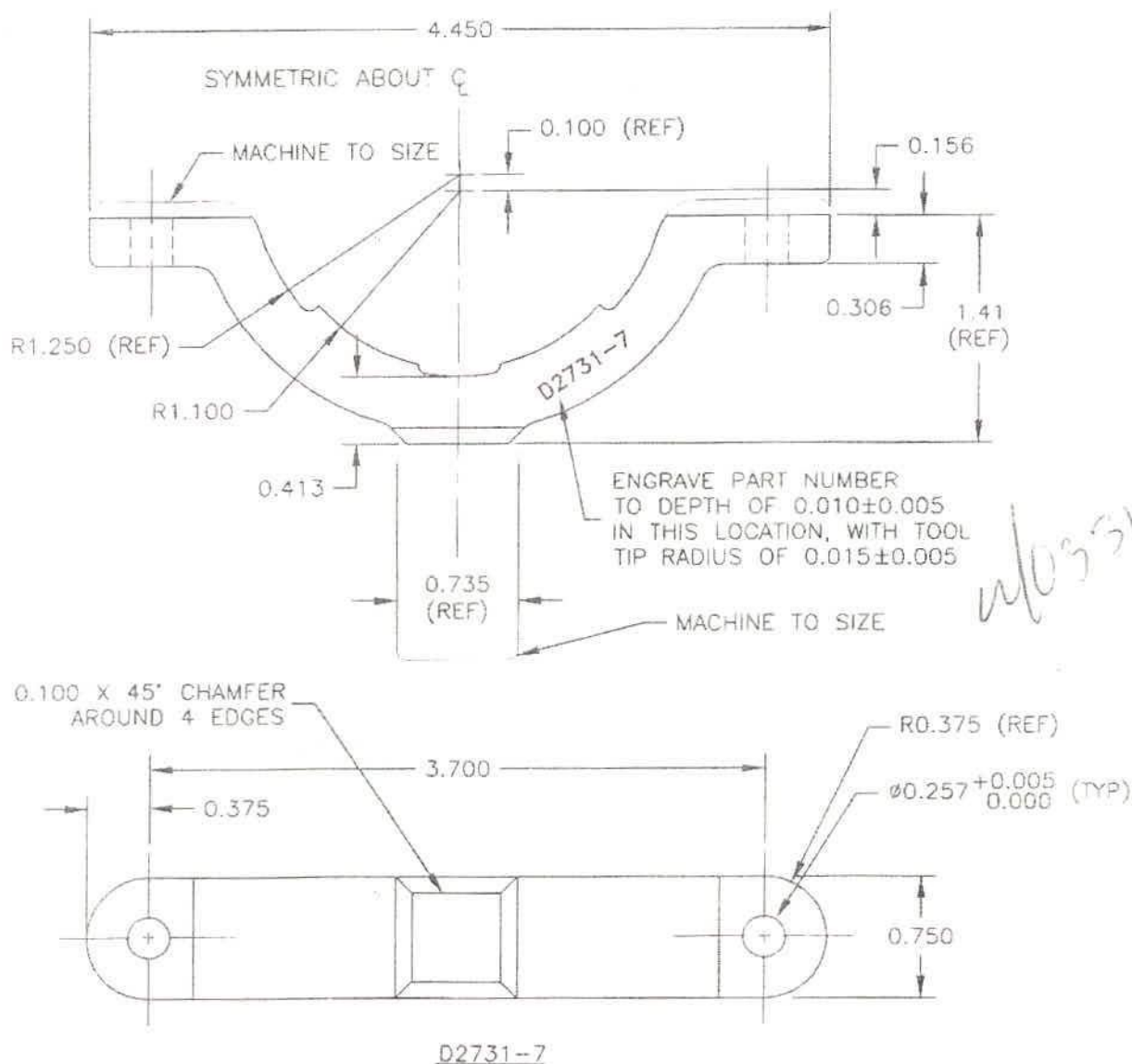
## Process Sheet

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Job Number: 33136		Part Number: D27317	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		JLL 07-06-29 (X4C)	
7.0	SPRAY PAINTING	SPRAY PAINTING	
			
Comment: SPRAY PAINT Delfleet Blue Clear Delfleet		7104105 6207107105 (8)	
ISSUE P.O TO ATELIER DEBOSELAGE			
8.0	QC14	INSPECT SPRAY PAINT	
			
Comment: INSPECT POWDER COAT		JLL 07-07-11 (8)	
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		7/7/11 SQ (8)	
10.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE		7/7/11 (8)	
Job Completion			
		u 07.07.12	



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.07.06 *KE*



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40

D2731-7

Lug B33136

4040

32

D3394-3

Lug B33138

4040

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

A handwritten signature in black ink, appearing to be "Denise Robinson", written over a horizontal line.

Denise Robinson

Vankleek Hill, June 27, 2007